

Work Order ID 114661

March-12-14 9:49:38 AM

Handwritten: 17/03
114661

Page 1

Item ID: D4712-1

Revision ID:

Item Name: Bracket

Start Date: 3/12/14

Start Qty: 24.00

24

Required Date: 3/12/14

Req'd Qty: 24.00

24

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: *[Signature]*

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4712

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Handwritten: 6061-040"

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

2-Deburr if necessary

0.00

Handwritten: 24

Handwritten: 0

Handwritten: Jm14-03-12

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Handwritten: 24

Handwritten: 0

Handwritten: Jm14-03-12

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Page 2

Item ID: D4712-1

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Start Date: 3/12/14

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24

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

0.00

DAS

27

9-89

4/3/12

24

130

Bend as per dwg

0.00

130

Brake NC

NC BRAKE

Memo

Brake NC

0.00

DAS

30

9-89

24

14/03/12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

Quality Control

0.00

DAS

27

9-89

4/3/12

24

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Page 3

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Start Date: 3/12/14

Start Qty: 24.00

24

Required Date: 3/12/14

Req'd Qty: 24.00

24

Reference:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: MF4

0.00

170

Packaging

Memo

0.00

Packaging

24 HB 14-3-1324 SAD 14/03/1324 SAD 14/03/13

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114661

Page 4

Item ID: D4712-1

Revision ID:

Item Name: Bracket

Start Date: 3/12/14

Start Qty: 24.00

24

Required Date: 3/12/14

Req'd Qty: 24.00

24

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampMC5 140374

MF 14-314

Picklist Print

March-12-14 9:49:38 AM

Page 1

Work Order ID: 114661

114661

Parent Item: D4712-1

D4712-1

Parent Item Name: Bracket

Start Date: 3/12/14

Required Date: 3/12/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

323.7100

0.0875

~~2210527~~

M6061T6S 040

2.5

Jm14-03-v2

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

323.71

m126350

51.3

m126981

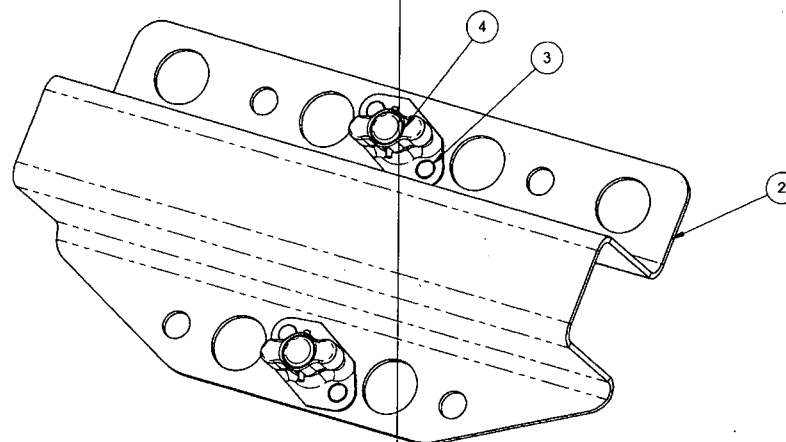
94.41

m128422

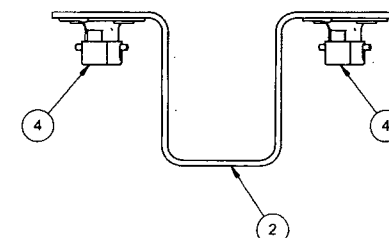
178

128422

ITEM NO.	QTY. .043	PART NUMBER	DESCRIPTION
1	X	D4712-043	BRACKET ASSEMBLY
2	1	D4712-3	BRACKET
3	4	MS20426AD3-2	RIVET
4	2	2350-18-C3Y	RIGID RECEPTACLE



D4712-043 BRACKET ASSEMBLY



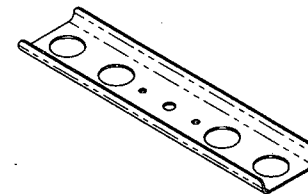
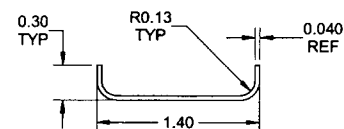
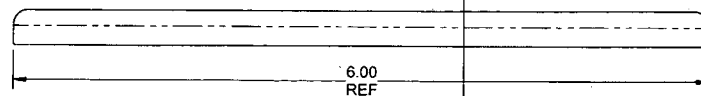
RELEASED
2013-12-23
ASS ECU13-705

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

w/o 114661

C	Ø0.129 WAS Ø0.098 (ZN C4-3)	RF	13.09.11
B	REMOVED -Ø41/-5; REMOVE CSK ON D4712-1F (ZN D4-3); Ø0.221 WAS Ø0.500 (ZN B4-3); REVISE D4712-3/-043 (ZN B4-4, B4-5)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	DS	D4712	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	CS	SUPPORT BRACKET ASSY	NTS
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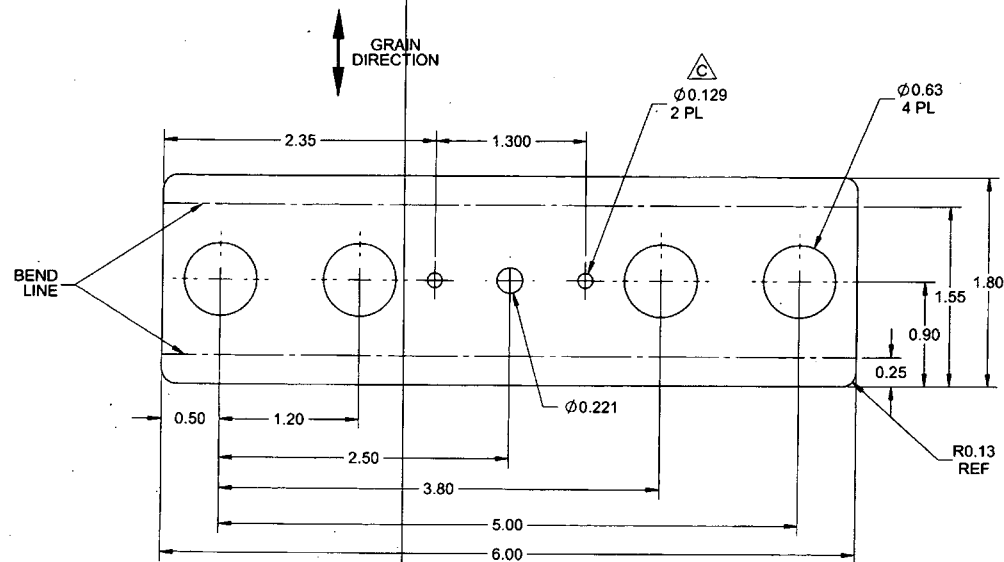
D4712-1 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4712-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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2013-12-23
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DRAWN	RF		
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MFG. APPR.	DS	D4712	SHEET 2 OF 5
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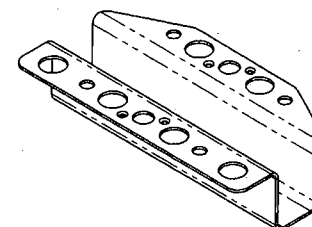
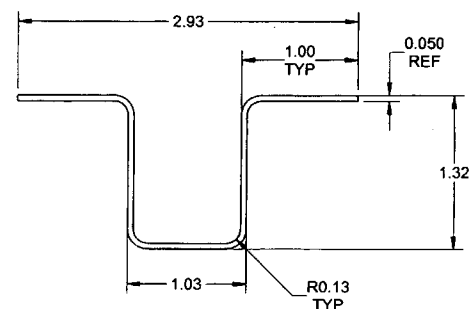
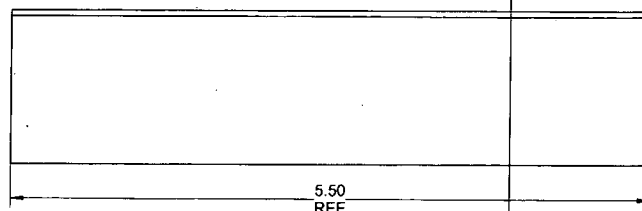
D4712-1F FLAT PATTERN BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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2013-12-23
ASS

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CHECKED	PL	DRAWING NO.	REV. C
MFG. APPR.	DS	D4712	SHEET 3 OF 5
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DE APPR.	PL	SUPPORT BRACKET ASSY	NTS
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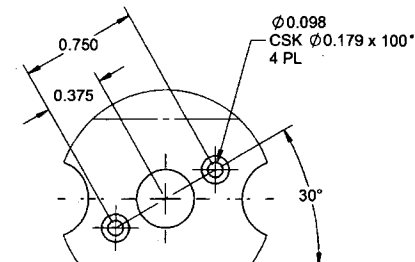
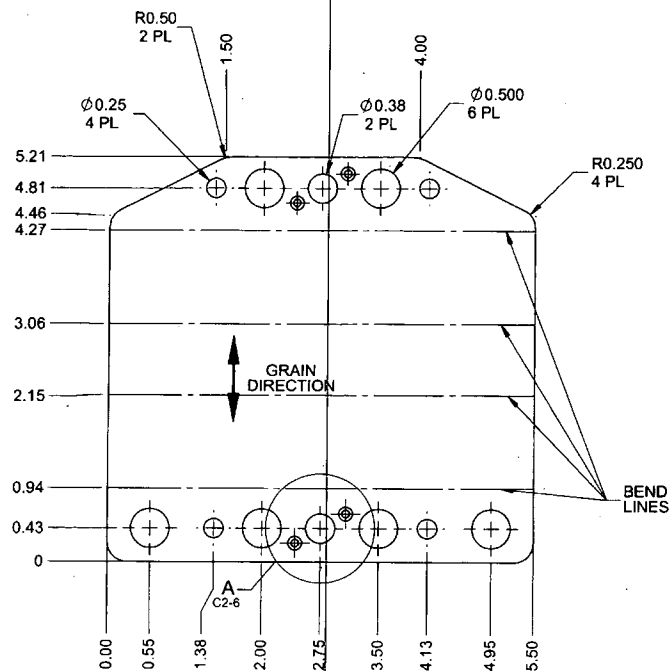
D4712-3 BRACKET

RELEASED
2013-12-23
ASS

NOTES:

- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	AS	D4712	SHEET 4 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SUPPORT BRACKET ASSY	NTS
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DETAIL A B6-6
2 PL D5-6

0.050
REF

D4712-3F FLAT PATTERN BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

RELEASED
2013-12-23
A/S

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CHECKED	OC	DRAWING NO.	REV. C
MFG. APPR.	N	D4712	SHEET 5 OF 5
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